

Date: Thursday, 4/26/2007 7:48:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 32071
 Estimate Number : 12711
 P.O. Number : N/A Part Number : D35373
 This Issue : 4/26/2007 S.O. No. : N/A Drawing Number : D3537 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : ~~PH~~ PH 07-04-26
 Previous Run : 31726 Material : C PH 07-05-23
 Written By : Due Date : 5/3/2007 Qty: 20 Um: Each
 Checked & Approved By : HA 07.04.26
 Comment : Est Rev:A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1512 sf(s)/Unit Total: 3.0240 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: m101813 ml 07 04 26

25213
~~20~~ 15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: B C ml 07 04 26
 Prog Rev: B C

20 10
PCW

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Parts were found @ the water jet 07-05-23
07-05-23

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3

Form Joggle as per Dwg D3537 on brake using Jig DT8158


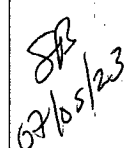

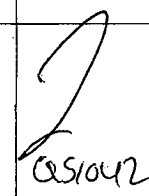
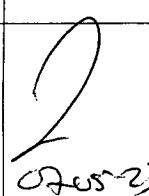
SB 07/06/01 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-23	2.0	5pm4s done to old Rev. No good.	 051042	Scr API: destray. Qty 10 @ New Dwg Rev. C.	 07/05/23	 0705-23	 051042	 0705-23

NOTE: Date & initial all entries

Date: Thursday, 4/26/2007 7:48:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 32071

Part Number: D35373

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

BD 07-06-04 (10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

Batch
M102956

FL 07/06/04 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/04 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/04 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601

BR/FL 07-06-04 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/06/04 (10X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: EP-18

M-L 07/06/04 (10X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W O Fabs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

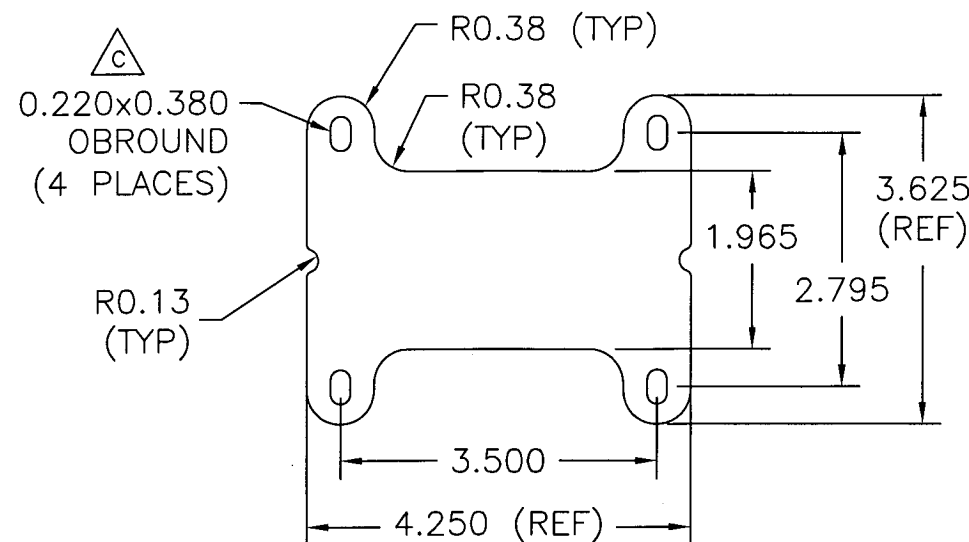
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

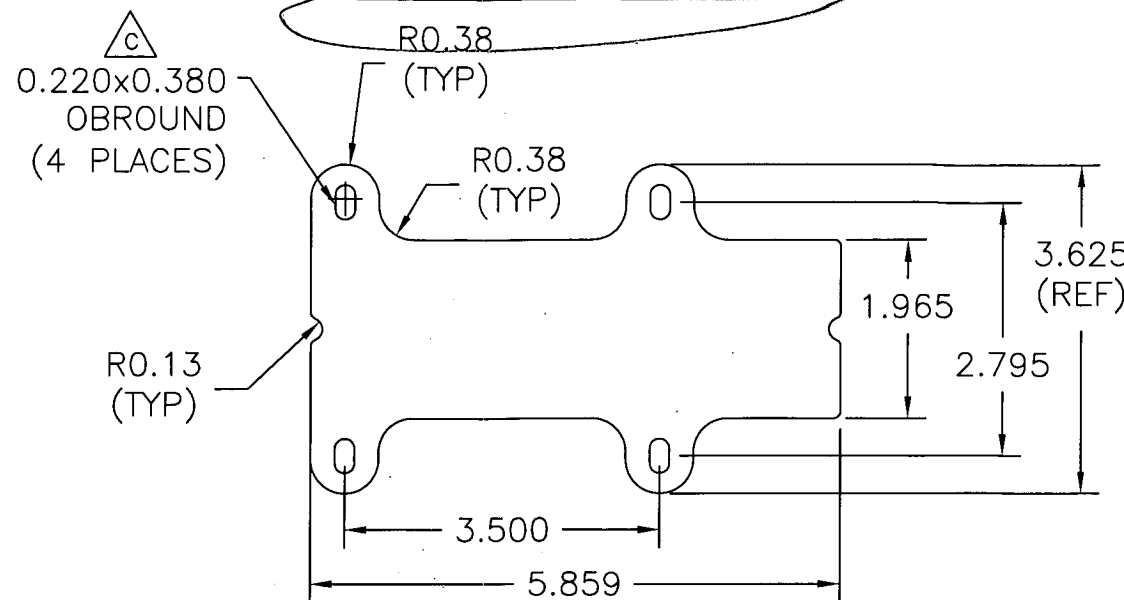
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

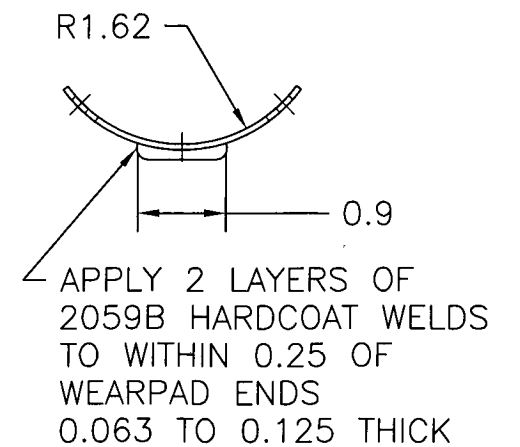
D3537-1F FLAT PATTERN



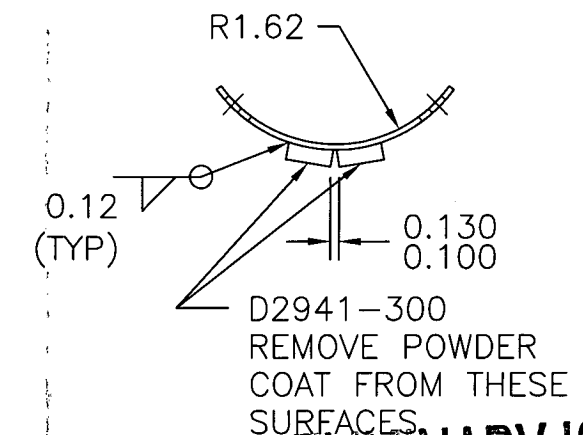
D3537-3F FLAT PATTERN



SECTION A-A

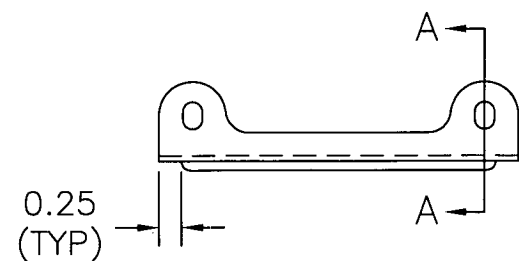


SECTION B-B

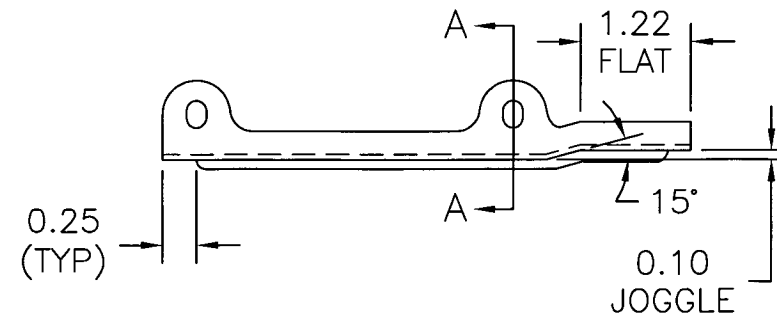


PRELIMINARY ISSUE

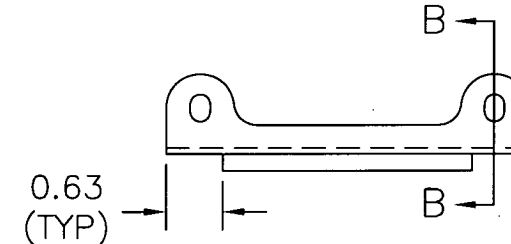
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



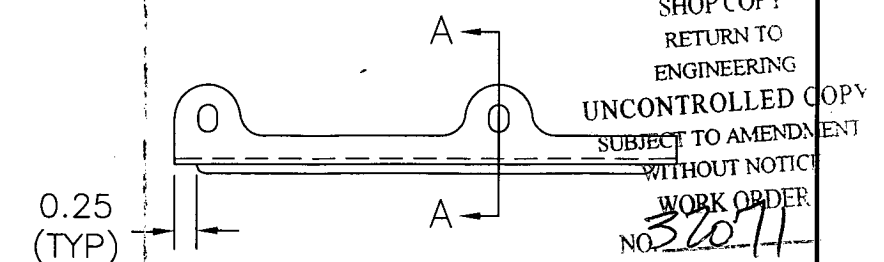
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY P.H.
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC. PORT HADLOCK, WA		DRAWING NO. D3537
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE LTD		Work Order: 32071
Description: Wearpad		Part Number: D3537-3
Inspection Dwg: D3537	Rev: B C PH 07.06.05	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.625	+/- 0.010	3.624	✓		VERN	
B 2.795	+/- 0.010	2.795	✓		VERN	
C 1.965	+/- 0.010	1.968	✓		VERN	
D 3.500	+/- 0.010	3.504	✓		VERN	
E 5.859	+/- 0.010	5.866	✓		VERN	
F 0.220 x 0.380	+/- 0.010	0.217 x 0.380	✓		VERN	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>ML ML</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>NA</i>
Date: 07 04 26	Date: 07 05 23	Date: <i>NA</i>
Rev	Date	Change
		New Issue
		Revised by
		KJ/RF
		Approved